

Work Order ID 60152

Monday, June 28, 2010 10:25:22 AM



Page 1

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Item Name: Bearing Assembly

Stop



Start Date: 6/28/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 6/28/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: CZ

Date: 10/6/28 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3183

Rev C1

Pick Kit

10-6-28 SL (152)

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

ES 10/6/28 (15)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Stolob 128

(15)

150

Identify as per dwg & Stock Location: 236

0.00



Packaging

Memo

0.00

Packaging

PC 10/6/28 (15)

Work Order ID 60152

Monday, June 28, 2010 10:25:22 AM



Page 2

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 6/28/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 6/28/2010 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

m 10-6-28

Picklist Print

Monday, June 28, 2010 10:25:21 AM

Page 1

Work Order ID: 60152

Parent Item: D3183-045

Parent Item Name: Bearing Assembly



Start Date: 6/28/2010

Required Date: 6/28/2010

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP A 04.02.18 New issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3183-9



Cap

Manufactured

No

Each

27.0000

0

10-6-28

Location

Loc Qty

Loc Code

ST236

27

47648

2

58327

25

2

13

D3183-5



Bearing

Manufactured

No

110

Each

53.0000

15

10-6-28

Location

Loc Qty

Loc Code

ST236

53

47606

1

52135

2

54421

10

59071

40

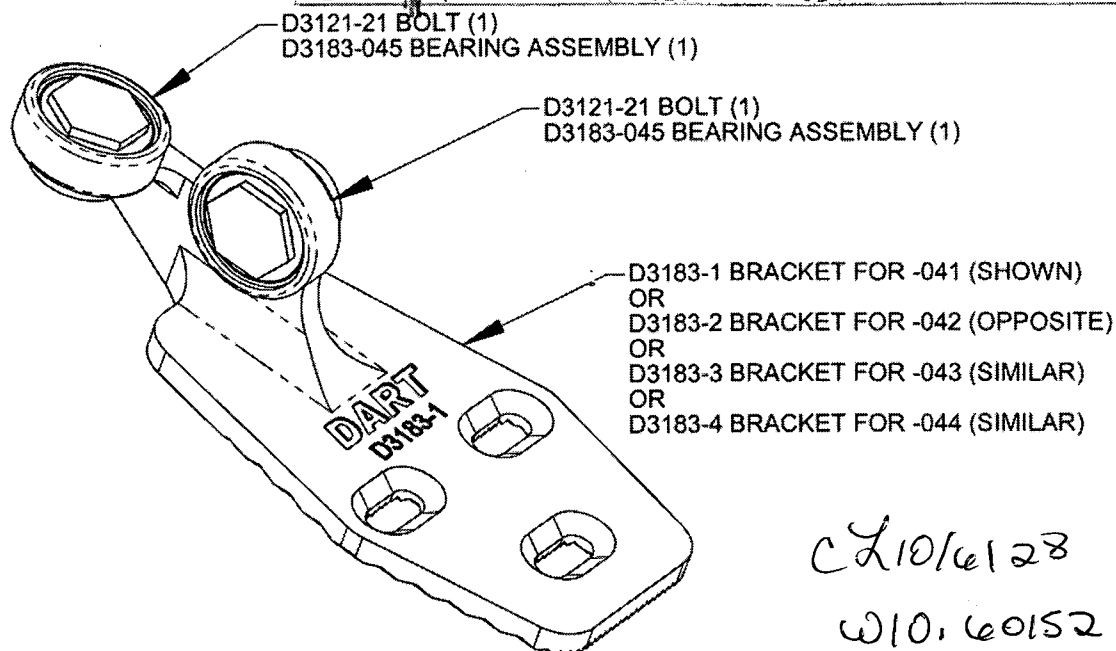
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5

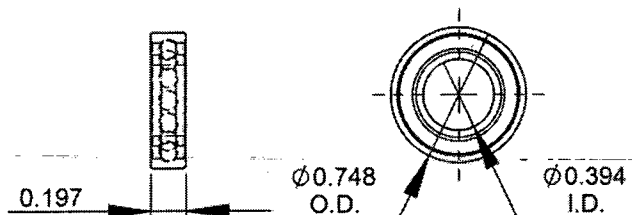


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

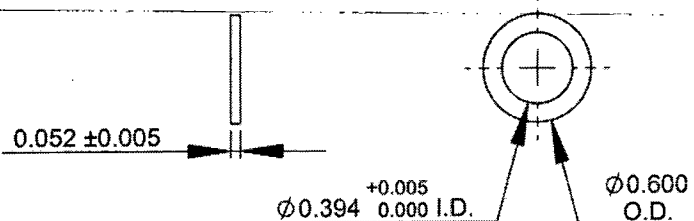


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

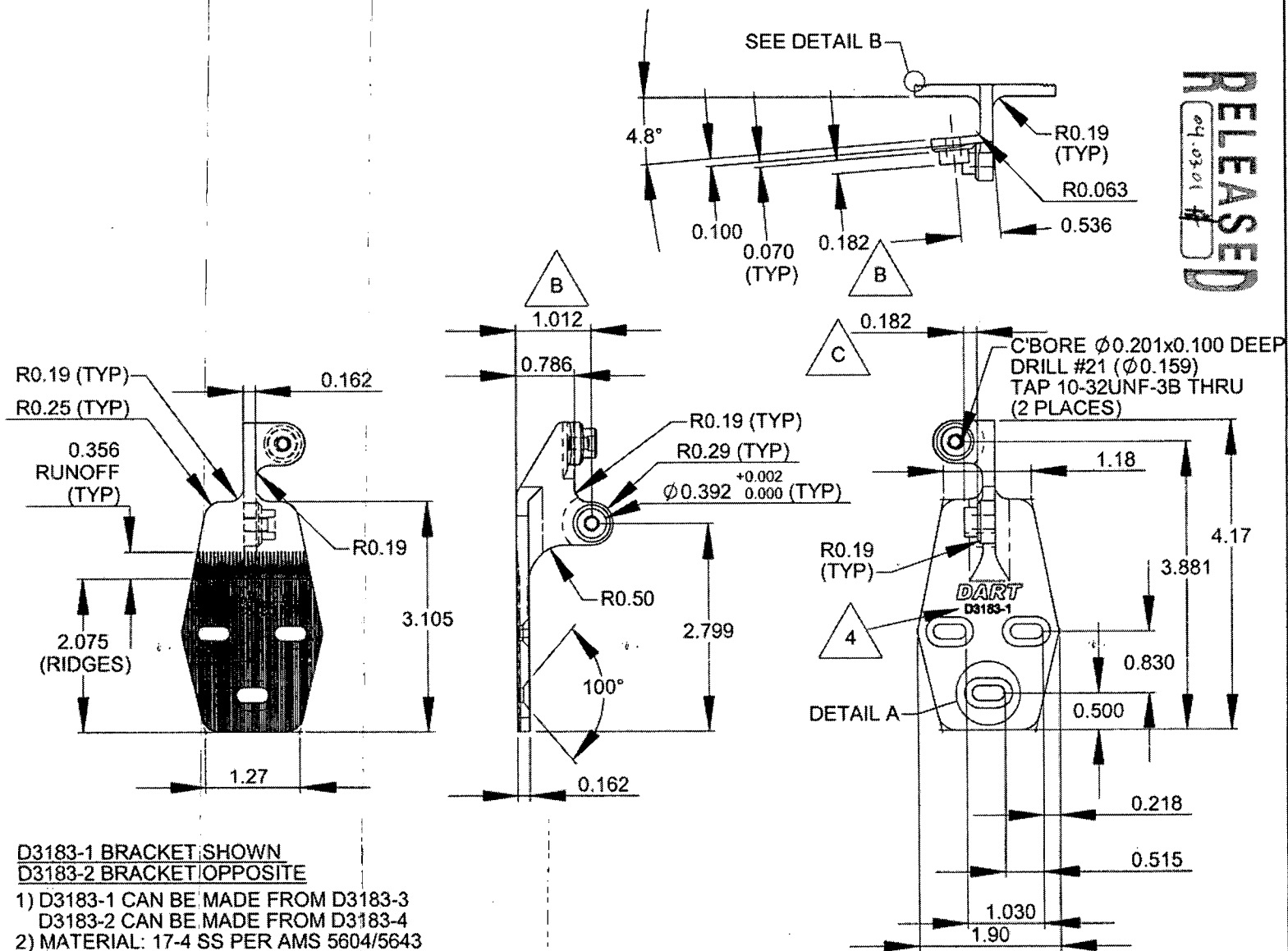
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE 1:2

RELEASED
04.03.01

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

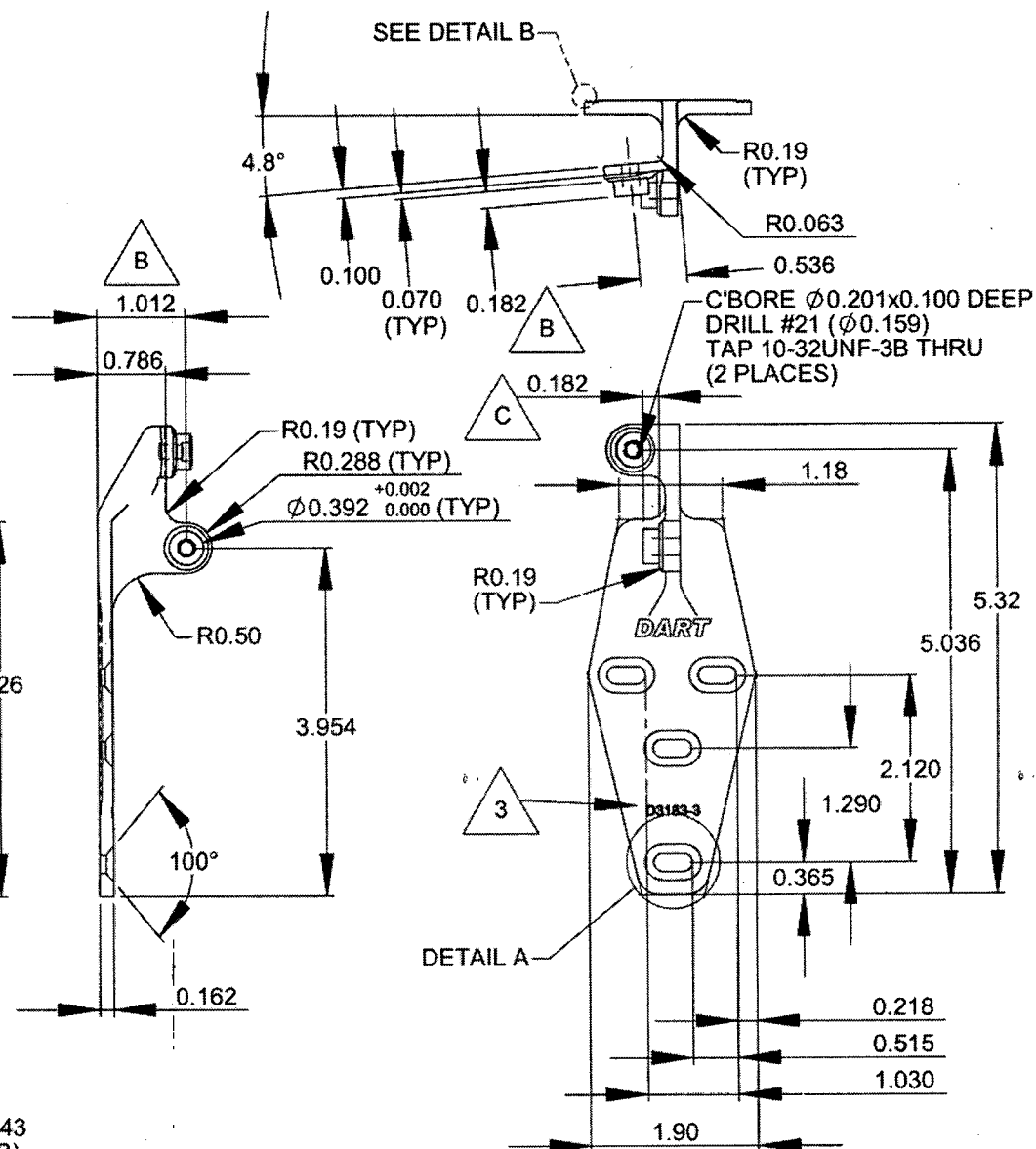
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD
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DATE	TITLE	REV. C
04.02.17	D3183	SHEET 3 OF 4
	BRACKET ASSEMBLY	SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

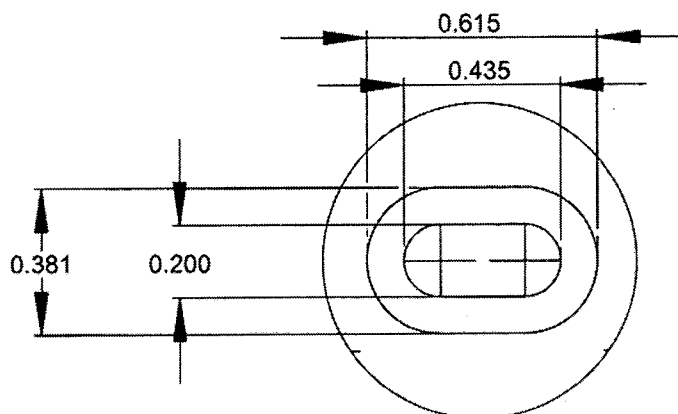
RELEASED
04.03.01

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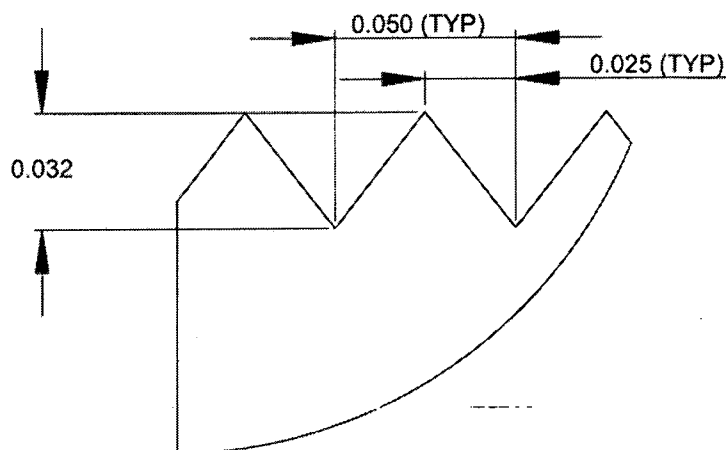


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

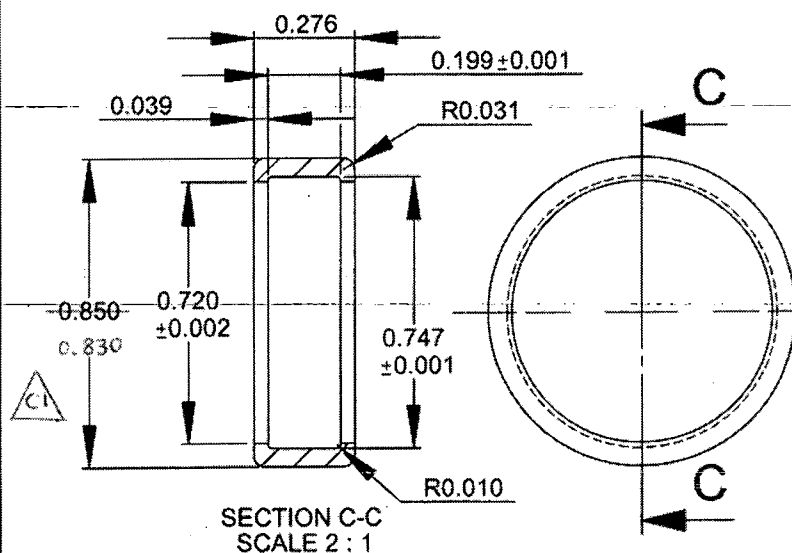


DETAIL A (2 : 1)

RELEASED
04.03.01 #



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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